

Delev 54673

Work Order ID 53889



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November 23, 2009 11:24:17 AM

Item ID:	D2583	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Latch Bracket					
Start Date:	23/11/2009	Start Qty: 20.00		Cust Item ID:		
Required Date:	27/11/2009	Req'd Qty: 20.00		Customer:		

Reference:

Approvals:	Process Plan:	<u>PL</u>	Date:	<u>09-11-23</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2583	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2583 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Debur if necessary

B 9-12-7

(32)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-12-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 8 07/12/07

Went to
(732)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00				32	0		
Brake NC	Memo	0.00	SB 09/12/14						
Brake NC	Deburr Form on CNC Brake as per Dwg D2583								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00	=> S 09/12/14						
Quality Control									
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00	BR 09-12-14						
Hand Finishing									

count
(32)

(32)

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Item ID: D2583

Accept



Setup Start



Revision ID: B

Stop



Item Name: Latch Bracket

Start Date: 23/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum <i>M112148</i> Memo START TIME: <i>10:20</i> <input type="checkbox"/> OVEN TEMPERATURE: <i>320</i> <input type="checkbox"/> FINISH TIME: <i>10:52</i>	0.00 0.00		<i>09-12-15</i>		<i>32</i>			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>09-12-15</i>		<i>32 X</i>			
180 Packaging Packaging	Identify as per dwg & Stock Location: <i>St 36</i> Memo	0.00 0.00		<i>09-12-16</i>		<i>X32</i>			

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 53889



Parent Item: D2583RevB



Parent Item Name: Latch Bracket

Start Date: 23/11/2009

Required Date: 27/11/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M5052H32S.040 Purchased

No

100

sf

121.8000

2.4611



5052-H32 .040 Sheet



HR 9-12-7

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

121.8

101875

8.125

102723

1

104921

6.5

106900

2

107513

4.5

109058

35.675

113123

64

107461

$101875 \times 12 = 1.4766$
 $102723 \times 3 = .369$
 $104921 \times 5 + 4 = 1.107$

.1230

$107461 \times 8 = .984$

(32)

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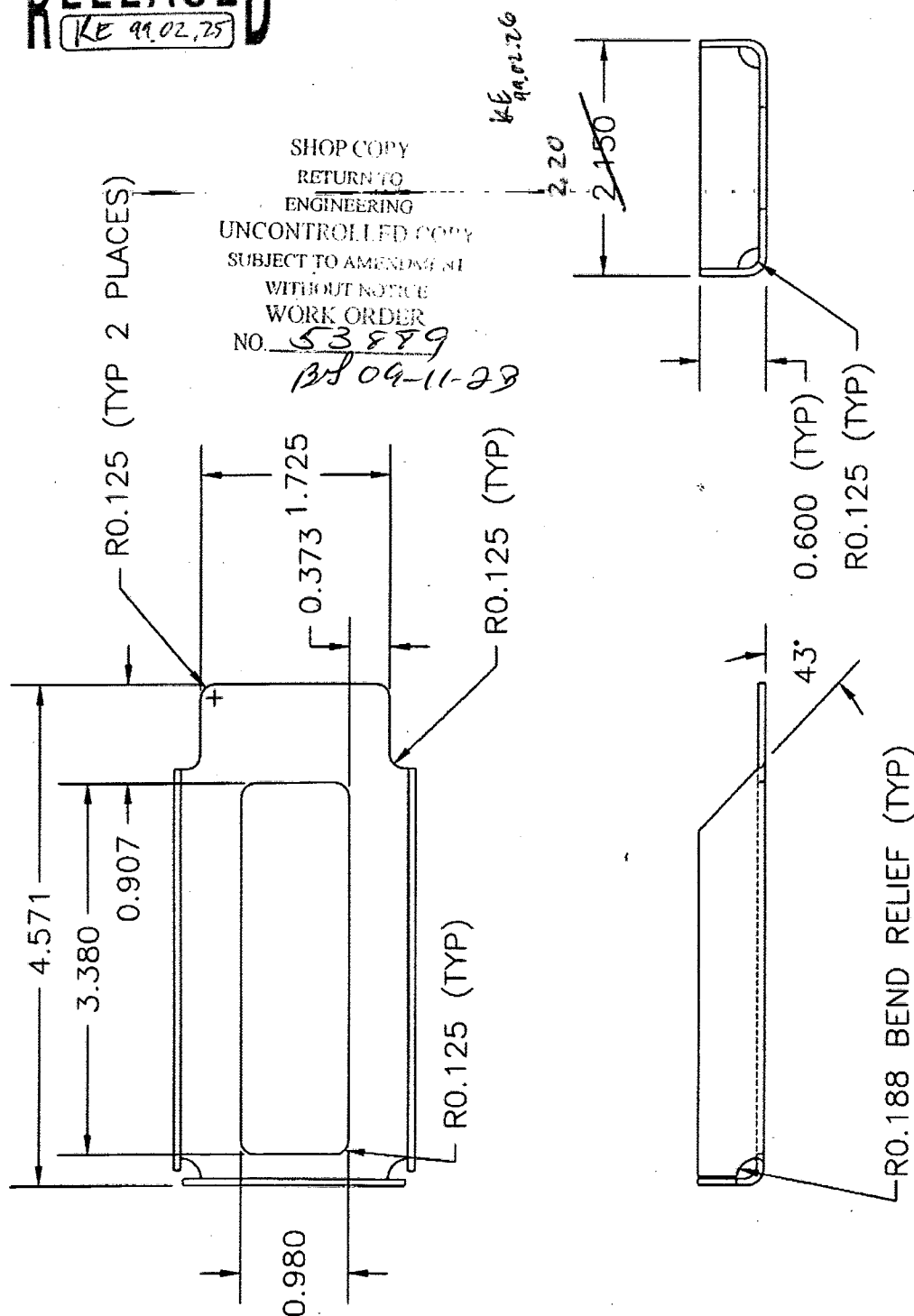
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DESIGN MIKE M.	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2583	REV. B SHEET 1 OF 1
DATE 99.02.22	TITLE LATCH BRACKET		SCALE 2:3
A	96.07.10	NEW ISSUE	
B	99.02.22	CHANGE OF FINISH (PER TSR A887)	

RELEASED
KE 99.02.25



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED